

Work Order ID 62414

Wednesday, September 29, 2010 1:53:58 PM

Page 1

Item ID: D119-646-451

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplates, LH, OEM

Start Date: 9/29/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 10-9-29 Tooling:

Date:

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI 9526

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file & type labels as per PPP D119-646-451/ DSI 9526 CHG 001

S106969

HJ for BG 10-9-29

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/9/29 sl

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S106969

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-646-451/ DSI 9526								
	Location: _____								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/9/29 *[Signature]*

10/09/29 *[Signature]*

MF 10-9-29

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62414

Parent Item: D119-646-451

Parent Item Name: Wearplates, LH, OEM







Start Date: 9/29/2010

Required Date: 9/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8 D4132-041  Wearplate, LH Fwd		Manufactured	No			110	Each	0.0000	1	1		10/9/29 SL	
6 D4133-041  Wearplate, Mid		Manufactured	No			110	Each	0.0000	1	1		10/9/29 SL	
5 D4134-041  Wearplate, LH Aft		Manufactured	No			110	Each	0.0000	1	1		10/9/29 SL	
8 D4135-1  Wearpad		Manufactured	No			110	Each	8.0000	3			10/9/29 SL	
<div> <div>Location</div> <div>FG</div> <div>60167</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div>3</div> </div>													
6 AEELS-1032-130  INSERT		Purchased	No			110	Each	0.0000	20	20		10/9/29 SL	
6 AEELS-1032-225  INSERT		Purchased	No			110	Each	0.0000	12	12		10/9/29 SL	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Parent Item: D119-646-451

Parent Item Name: Wearplates, LH, OEM

Start Date: 9/29/2010

Required Date: 9/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

110

Each

1,026.000

54

54



Bolt



10/9/2010

Location

Loc Qty

Loc Code

ST350

1016

114330

11

115015

16

115108

13

115316

276

115371

100

115422

100

115594

500

ST351

10

113121

10

54

NAS1149C0332R

Purchased

No

110

Each

635.0000

54

54



Washer



10/9/2010

Location

Loc Qty

Loc Code

ST297

635

113524

10

113737

150

115000

125

115698

350

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

REFERENCE ONLY

PARTS LIST

QTY -451	QTY -452	PART NUMBER	DESCRIPTION
X		D119-646-451	WEARPLATE KIT, OEM LH
	X	D119-646-452	WEARPLATE KIT, OEM RH
1		D4132-041	WEARPLATE, FWD LH
1		*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4132-042	WEARPLATE, FWD RH
	1	*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
1	1	D4133-041	WEARPLATE, MID
1	1	*D4133-3	GASKET (BONDED WITH 3M 1300/1300L)
1		D4134-041	WEARPLATE, AFT
1		*D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4134-042	WEARPLATE, AFT
	1	.D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
3	3	D4135-1	WEARPAD
20	20	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
54	54	AN3C5A	BOLT
54	54	NAS1149CO332R	WASHER

* denotes that part is included in assembly above

WEIGHT AND BALANCE

The following weight and balance information is for the Dart D119-646-451/-452 kits only. The weight and balance of the wearplates removed are the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-451	10.8 lb	117.7 in	1271 in lb	-39.4 in	-426 in lb
WEARPLATE KIT, LH	4.9 kg	2.99 m	14.7 m kg	-1.00 m	-4.9 m kg
D119-646-452	10.8 lb	117.7 in	1271 in lb	+39.4 in	+426 in lb
WEARPLATE KIT, RH	4.9 kg	2.99 m	14.7 m kg	+1.00 m	+4.9 m kg

DESIGN	92	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	92		
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9526	SHEET 2 OF 3
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	OEM WEARPLATE KIT	NTS
DATE	10.06.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	